

# Work Order ID 74634

Tuesday, October 04, 2011 1:42:29 PM



Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	10/4/2011	Start Qty:	1.00			
Required Date:	10/14/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	<u>M.L.S</u>	Date:	<u>11/10/08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3914	B								

100	Weld per dwg A/R S.S. rod Batch: <u>117884</u>	0.00							
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	Large Fab								
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Large Fab									
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## Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A  
 2- weld hinge (3) and Mounting brackets as per dwg D3914  
 \*\*\*inspect before welding mesh\*\*\*  
 3- tack weld mesh on basket as per dwg D3914  
 \*\*\*make sure to place mesh correctly on lid, check with label plate before  
 tacking mesh\*\*\*

*PL 11.10.12*

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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QC									
----	--	--	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

## Memo

0.00

*BE  
11.10.14*

*1 / 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74634

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Page 2

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Item Name:	Long Basket Lid Assembly (350)					
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Required Date:	10/14/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00							
130  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo *** mask sides of hinge prior to powdercoat*** Start Time: 2:10 Oven Temperature: 320°F Finish Time: 2:40	0.00 0.00							
140  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M118980  Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00							

M117338

1X2 M/L 11/10/18

1 0 11 11/10/19

P70

W/O: 74634		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3914-041 PAR #: N/A Fault Category: Large FAP + QC Inspected NCR: (Yes) No DQA: 11/10/28 Date: 11/10/28  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed Date: 11/11/01

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/20	Form # 1410	Found at QC3 / Assembly that the holes in lid for the gas strut were in the wrong location they are at the end	11.10.25 GSI042 ATTACHED EMAIL	Drill holes in correct location. AND weld per as per D4021-9 B 72480 at 2. AS per Dwg D4035-01	Cpl 11.10.25	11/10/25	11.10.25	11/10/20
	Missed @ #100 + 120	end not @ the AFT END AS per Dwg. E-C R B was welded in wrong orientation (inverted). + MISSED AT INSPECTION	11.10.25 GSI042 ATTACHED EMAIL	A/R SS 11/11/25 Re powder coat as per Dwg. Start temp 3200 F in 3200	M. 11/10/25	11/10/26	11.10.25	11/10/20
		Re: LOA		(see Attached E-mail from D.S to E.D.)				

NOTE: Date & initial all entries

**Work Order ID 74634**

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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Sulw/26

160

Identify as per dwg & Stock Location: w/o

0.00



Packaging

Memo

0.00

Packaging

D4030-041/B74631

11/10/20

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27

YMF  
11-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, October 04, 2011 1:42:25 PM

Page 1

Work Order ID: 74634

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2581



Mounting Bracket

Manufactured

No

100

Each

18.0000

2

2



PL11.10.11

Location

Loc Qty

Loc Code

WA

18

69739

2

70766

2

73079

14

D3914-1



Rib

Manufactured

No

100

Each

1.0000

2

2



PL11.10.11

Location

Loc Qty

Loc Code

WA

1

72656

1

D3914-7



Rib

Manufactured

No

100

Each

0.0000

2

2



B74637 → ①  
B74643 → ② PL11.10.11

D4016-3



Hinge Half, Lid

Manufactured

No

100

Each

19.0000

3

3



PL11.10.11

Location

Loc Qty

Loc Code

WA

18

73630

18

WA005

1

71941

1

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, October 04, 2011 1:42:25 PM

Page 2

Work Order ID: 74634

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5  
Rib  
Manufactured No

100 Each

5.0000

9

9



Pl 11.10.11

Location

Loc Qty

Loc Code

WA

5

70758

5

B73943 → ⑨

D4020-5  
Mesh (350 Basket Long, Lid)  
Manufactured No

100 Each

2.0000

1

1



Pl 11.10.12

Location

Loc Qty

Loc Code

WA

2

68234

1

69162

1

B73935 → ①

D4021-3  
Data Plate  
Manufactured No

100 Each

7.0000

1

1



Pl 11.10.11

Location

Loc Qty

Loc Code

WA

7

73632

1

6

①

D4035-041  
Lid Rib Assembly, Fwd (350 Basket)  
Manufactured No

100 Each

0.0000

1

1



B73634 → ① Pl 11.10.11

D4035-043  
Lid Rib Assembly, Aft (350 Basket)  
Manufactured No

100 Each

5.0000

1

1



Pl 11.10.11

Location

Loc Qty

Loc Code

WA006

5

73628

5

①

Tuesday, October 04, 2011 1:42:26 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, October 04, 2011 1:42:26 PM

Page 3

Work Order ID: 74634



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



M115050648 11/10/20

Tuesday, October 04, 2011 1:42:26 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

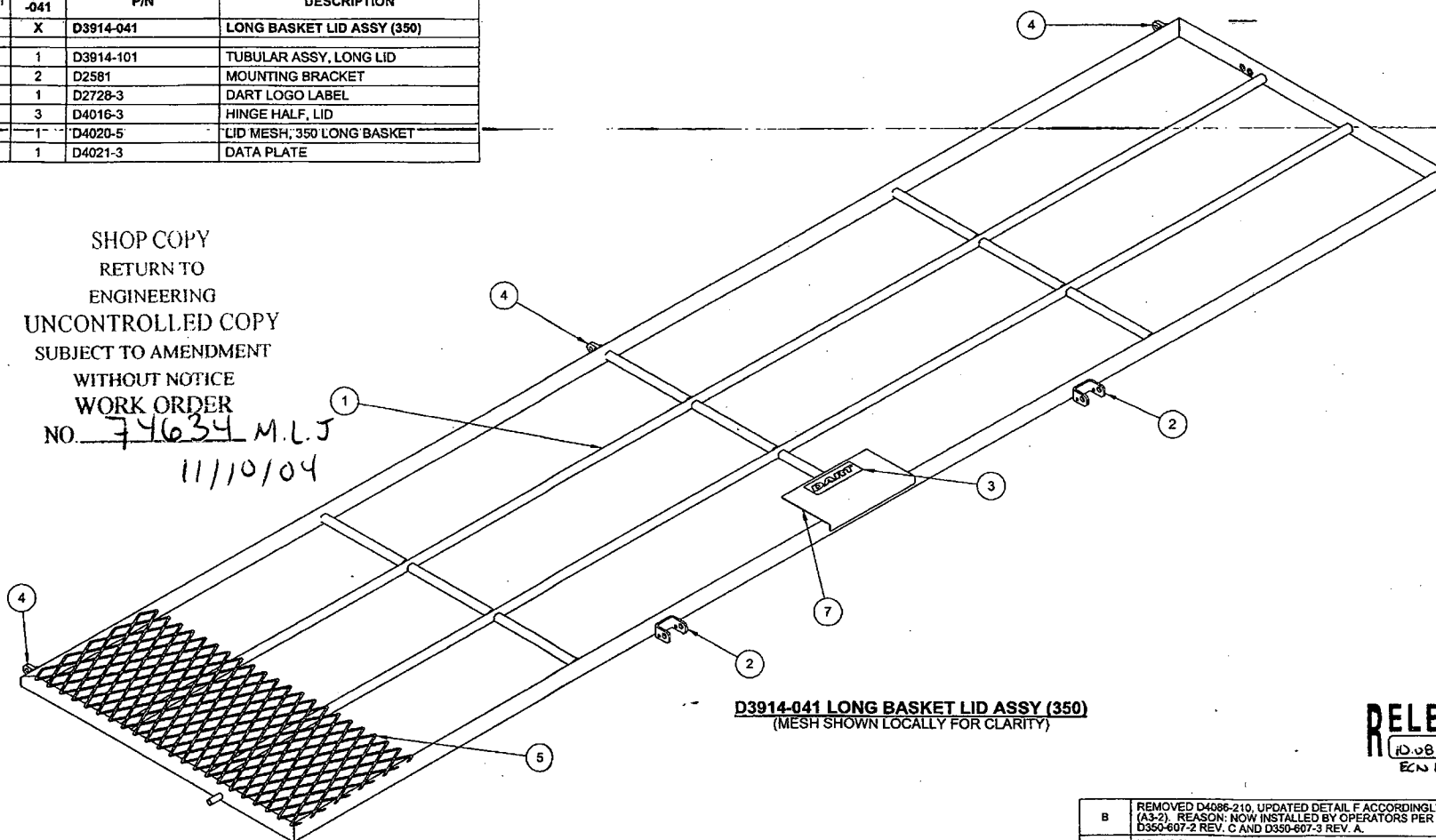
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74634 M.L.J

11/10/04



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	A.S.		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	S.C.		DRAWING NO.	REV. B
CHECKED	S.C.		D3914	SHEET 1 OF 4
MFG. APPR.	M.L.J.		TITLE	SCALE
APPROVED	M.L.J.		LONG BASKET LID ASSY (350)	NTS
DE APPR.	M.L.J.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.08.05			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

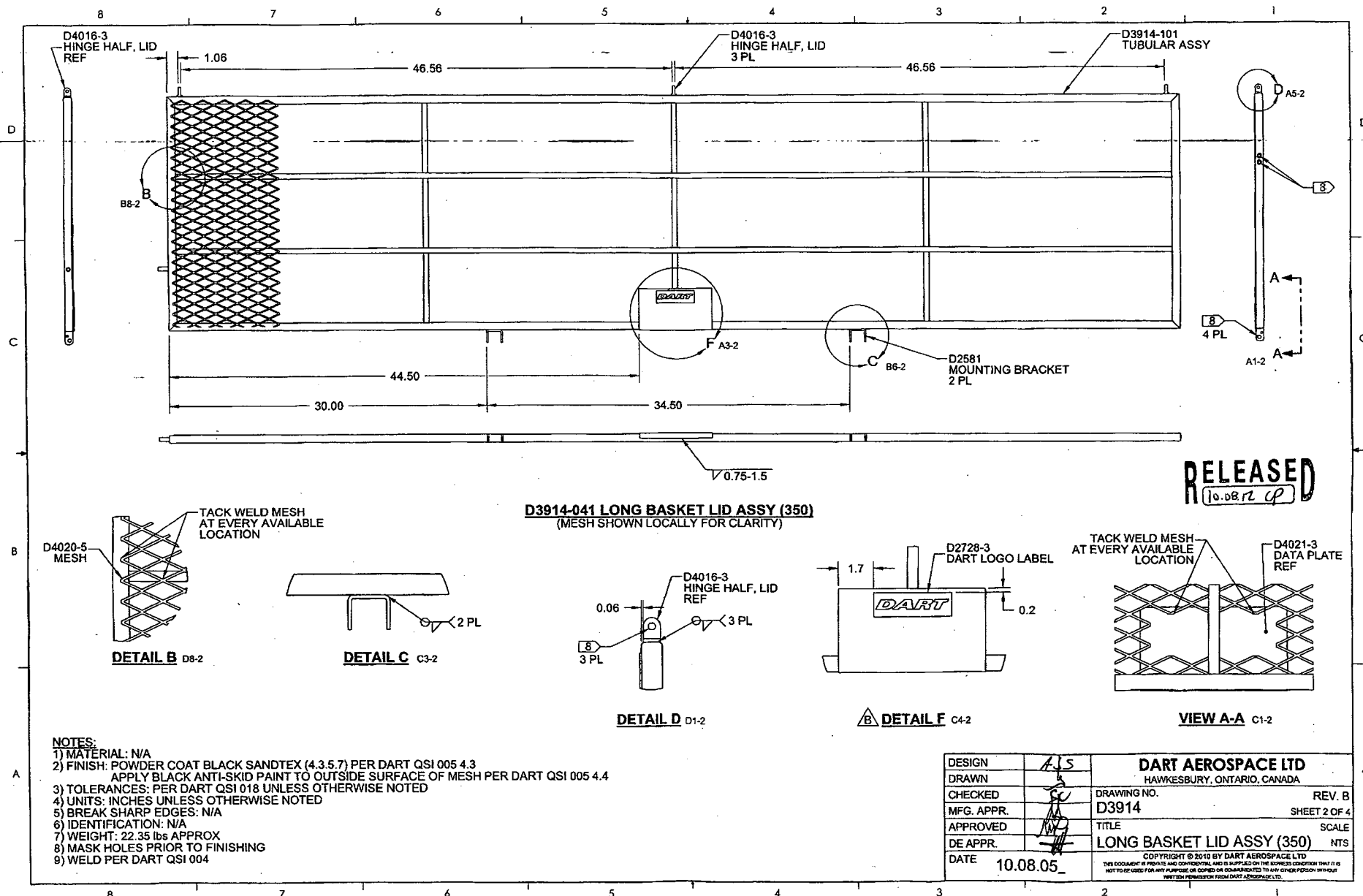
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

74634



D3953-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



74634

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

0.25

SECTION E-E C5-3

D4035-041  
RIB ASSY, FWD

TYP

E C2-3

TYP

D4035-043  
RIB ASSY, AFT

22.50

6.67  
TYP

TYP

D3914-1  
RIB  
2 PLD4018-5  
RIB  
9 PLD3914-7  
RIB  
2 PL23.25  
TYP

8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED  
10.08.12

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3914	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

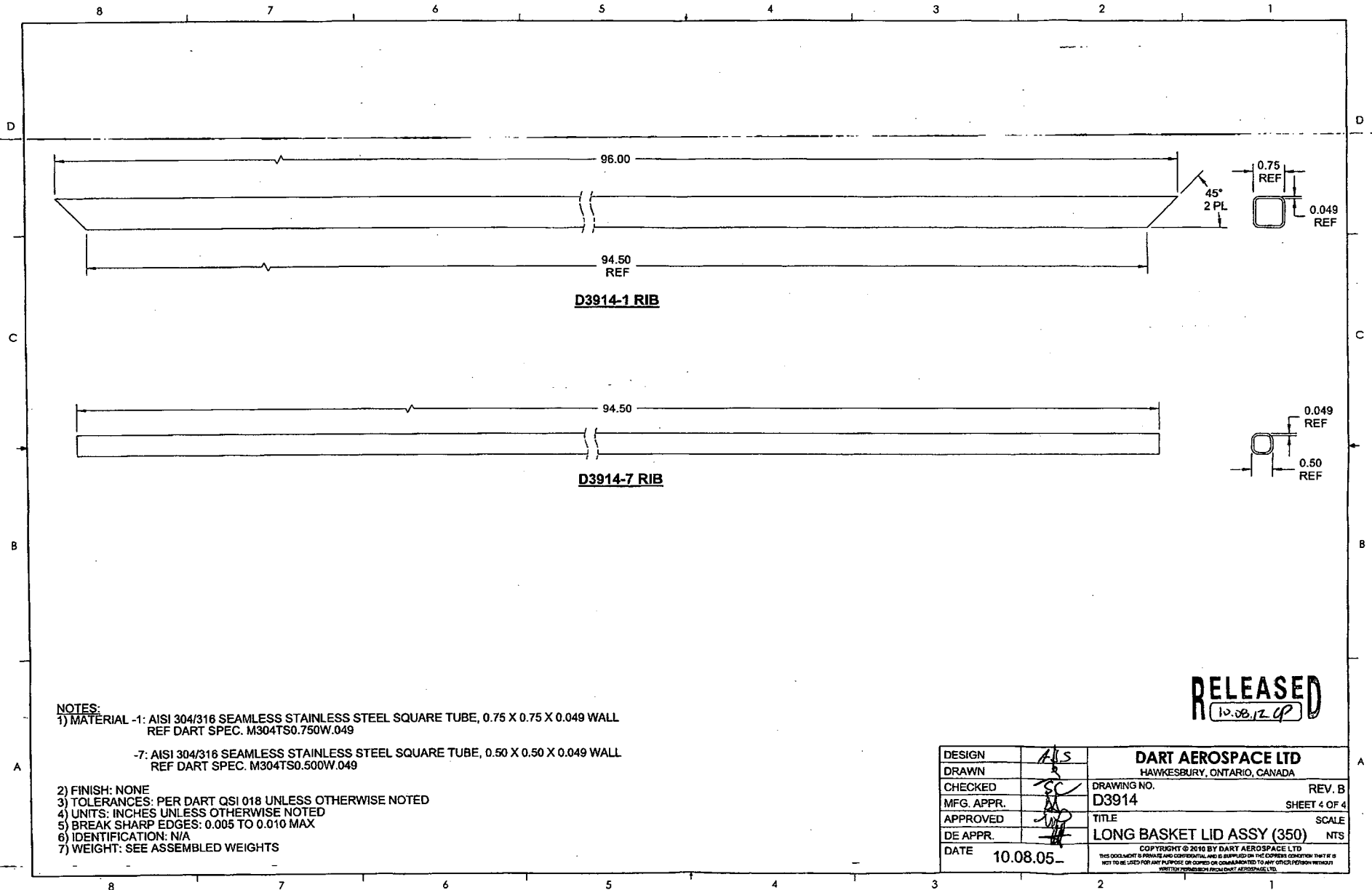
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74634



**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
10.08.12 LP

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## Eric Downing

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** October 21, 2011 7:12 PM  
**To:** 'Eric Downing'  
**Cc:** 'Linda Lacelle'; 'Bill Beckett'; dduval@dartaero.com; 'Marc Bellavance'; 'Mike Petsche'; 'Eric Charbonneau'  
**Subject:** RE: D3914-041 basket lid

**REFERENCE ONLY**

Eric,

Yes ... I agree that you should leave those holes in as "speed holes" and add the holes/bushings at the correct location.

Appropriate You Tube reference .... [www.youtube.com/watch?v=XVV\\_COOey0E](http://www.youtube.com/watch?v=XVV_COOey0E)

David

---

**From:** Eric Downing [mailto:edowning@dartaero.com]  
**Sent:** October-20-11 9:22 AM  
**To:** 'David Shepherd'; Marc Bellavance; Eric Charbonneau  
**Cc:** Linda Lacelle; Bill Beckett; dduval@dartaero.com; Marc Bellavance; 'Mike Petsche'  
**Subject:** D3914-041 basket lid

Hey Guys

During assembly / QC3 it was found that the holes on D4035-043 for the Gas Strut are in the wrong orientation. They are at the fwd end to in the aft end as they should be. It was missed at inspection by me so it is my fault as well as the person who welded it. Please see the attached picture to see what is incorrect.

Dave

Can we drill and weld the bushings in the correct location and leave the originals where they are? Think that that would be the easiest rework.

Eric

Also I found that the jig for welding only has a marker line to place the rib in the correct orientation could we have a block welded on the jig with the two holes in it to pin the rib in the correct spot so that this can never happen again? You could use a D3953-17/-13. What do you think

Thanks

**Eric Downing**  
**QC COORDINATOR**  
**DART AEROSPACE**  
**EDOWNING@DARTAERO.COM**

*Per Eric  
Stamp instructions  
directly on jig  
clean and dry,  
clean on jig  
lack of attention  
11/1/11*